

Work Order ID 110589

110589

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Friday, January 03, 2014 10:06:17 AM

Item ID: PB67-43001-97

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Clevis

Stop

NS2

Start Date: 1/3/2014 Start Qty: 8.00

8

Cust Item ID:

Required Date: 1/31/2014 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: MF Date: 14-01-03 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001	C								
100		0.00							
100									
Doosan	Memo	0.00							
Doosan Lathe	Turn as per Folio FA <u>FASS3</u> & Dwg B67-43001								
						8	0		DAS 40 9-89 14/01/07
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
						8	0		DAS 40 9-89 14/01/07
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									
						8	0		DAS 08 9-89 14/01/08

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N900040100Setup Start ***NS1***

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Stop ***NS2***

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

14-01-10
14-1-10

Picklist Print

Friday, January 03, 2014 10:06:15 AM

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Work Order ID: 110589

Parent Item: PB67-43001-97

Start Date: 1/3/2014

Required Date: 1/31/2014

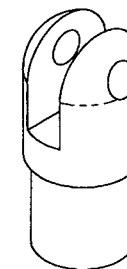
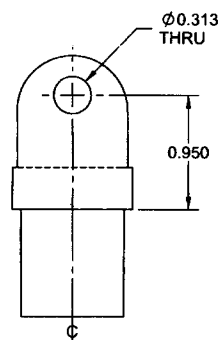
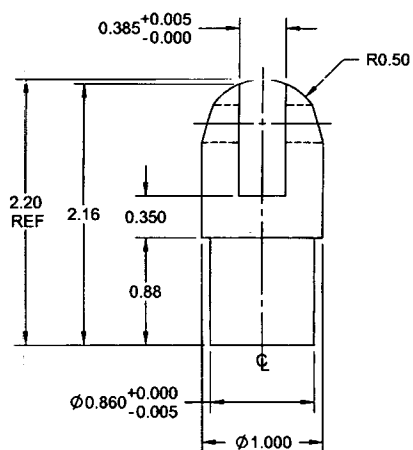
Parent Item Name: Clevis

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP B05.10.14Removed powder coat & added step 9KJ/EC
IPP Rev:B Now on Doosan Lathe 08-06-25 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R1.000 ROUND BAR 1.00"		Purchased	No			100	f	58.0000	0.1833	2		DAS 40 9-85 14/01/07	
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						MAT013		58					
						→ m126593		58		2			



B67-43001-97 CLEVIS

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 30 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.02.24
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD		
DRAWN		HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV. C	
MFG. APPR.		B67-43001-97	SHEET 1 OF 1	
APPROVED		TITLE	SCALE	
DE APPR.	N/A	CLEVIS	NTS	
DATE	09.02.24		COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DART AEROSPACE LTD	Work Order: 110589
Description: Clevis	Part Number: PB67-43001-97
Inspection Dwg: PB67-43001-97 Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.385	+ .005 - .000	.385	✓		VERW	P40-12
R .50	+ .030 - .030	.500	✓		Rad G	
Ø 1.000	± .010	.998	✓		VERW	P40-12
Ø .860	+ .005 - .005	.859	✓		"	"
2.20	± .030					
2.16	± .030	2.164	✓		"	"
.88	± .030	.881	✓		"	"
.350	± .010	.350	✓		"	"
Ø .313	+ .006 - .001	.314	✓		"	"
.950	± .010	.951	✓		"	"

Measured by: DAS 40	Audited by: J.A. DAS 08	Preliminary Approval:
Date: 14/01/07	Date: 14/01/08	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15